

Date: Thursday, 11/15/2007 9:30:22 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLOAT SKIDTUBE	
Job Number	: 34838		Part Number	: D412742013	
Estimate Number	: 10366		Drawing Number	: N/A UNDER REVIEW	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/15/2007 S.O. No. : N/A		Drawing Revision	: N/A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: 9/25/2007 Type : LANDING GEAR		Due Date	: 10/15/2007 Qty: 1 Um: Each	
Previous Run	: 34837				
Written By	: JLM 07.11.15				
Checked & Approved By	: Est Rev:A 05.10.13 New Issue KJ/JLM				
Comment	: Est Rev:B 06-06-08 As per DS19336 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D412-742-013 CHG003		
2.0	34838A	FLOAT SKID ASSEMBLY
Comment: Sub-Component FLOAT SKID ASSEMBLY D412-742-043 B		
3.0	D2571	Saddle, Fwd, Out
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2571 Saddle Fwd Outside		
4.0	D2572	Saddle, Fwd, In
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2572 Saddle Fwd Inside		
5.0	D2573	Saddle, Aft, Out
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2573 Saddle Aft Outside		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 34838		Part Number: D412742013
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	D2574	Saddle, Aft, In 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
Pick: Qty Part Number Description 1 D2574 Saddle Aft Outside <u>34840</u>		
7.0	D2747	Set Screw 
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick: Qty Part Number Description 4 D2747 Bolt <u>33470</u>		
8.0	D2876	Saddle Spacer 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Pick: Qty Part Number Description 2 D2876 Saddle Spacer <u>29788</u>		
9.0	D2877	Saddle Spacer 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Pick: Qty Part Number Description 2 D2877 Saddle Spacer <u>32104</u>		
10.0	D34031	Bushing 
Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)		
Pick: Qty Part Number Description 16 D3403-1 Bushing <u>33786</u>		
11.0	D34033	Bushing 
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)		
Pick: Qty Part Number Description 8 D3403-3 Bushing <u>34009</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 34838

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 D3405041 Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description
1 D3405-041 GHW Lug

Batch

32890

EW

13.0 D3405043 Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description
1 D3405-043 GHW Lug

Batch

34841

SP

14.0 AN4C6A Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
16 AN4C6A Bolt M105426

EW

15.0 AN4C46A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN4C46A Bolt M19529

EW

16.0 AN4C52A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 AN4C52A Bolt M19512

EW

17.0 AN6C12A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 AN6C12A Bolt M104289

EW

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Date: Thursday, 11/15/2007 9:30:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FLOAT SKIDTUBE
Job Number: 34838		Part Number: D412742013
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
18.0	AN960C416L 	WASHER 
<i>R</i> Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)		
Pick: Qty Part Number Description Batch 32 AN960C416L Washer <u>M10661</u> <i>CD</i>		
19.0	AN960C616L 	WASHER 
<i>R</i> Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)		
Pick: Qty Part Number Description Batch 8 AN960C616L Washer <u>M18822</u> <i>CD</i>		
20.0	AN960C716L 	WASHER 
<i>R</i> Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)		
Pick: Qty Part Number Description Batch 16 AN960C716L Washer <u>M104093</u> <i>CD</i>		
21.0	MS210434 	Nut 
<i>R</i> Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)		
Pick: Qty Part Number Description Batch 29 MS21043-4Nut <u>M105793</u> <i>CD</i>		
22.0	NAS1515H4L 	WASHER 
<i>R</i> Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)		
Pick: Qty Part Number Description Batch 32 NAS1515H4L Washer <u>M105728</u> <i>CD</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: FLOAT SKIDTUBE

Job Number: 34838

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation:

Description :

23.0 NAS1515H6L WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 NAS1515H6L Washer M18918

24.0 NAS1515H7L WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
16 NAS1515H7L Washer M101727

25.0 D3407041 Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3407-041 TOW RING 34010

26.0 D34173 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3417-3 WASHER 33519

27.0 D34561 washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3456-1 WASHER M33276

28.0 AN4C7A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M101427

11/15/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 01/11/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 34838		Part Number: D412742013
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
29.0	QC4 	INSPECT 100% KITS FOR COMPLETENESS  ① <i>7-11-16 SP 6</i>
30.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: INSPECT 100% KITS FOR COMPLETENESS		
Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-742-013 Location: <i>3</i> 7-11-16 SP 6		
31.0	QC21 	FINAL INSPECTION/W/O RELEASE  ① <i>7-11-17</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion  <i>7-11-17</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

& initial all entries

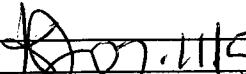
Ship Monday 19/11

Dart Aerospace Ltd.

Date: Thursday, 11/15/2007 9:30:34 AM
User: Kim Johnston

Process Sheet

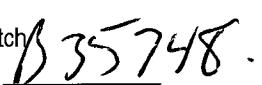
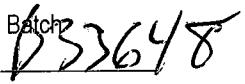
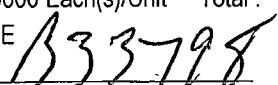
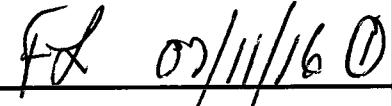
42

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLOAT SKID ASSEMBLY	
Job Number	: 34838A		Part Number	: D412742043	
Estimate Number	: 10756		Drawing Number	: D3391 REV F	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/15/2007 S.O. No. : N/A		Drawing Revision	: F	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: 9/25/2007 Type : LANDING GEAR		Due Date	: 10/15/2007	
Previous Run	: 34837A		Qty:	1 Um: Each	
Written By	: 				
Checked & Approved By	: 				
Comment	: Est Rev A 05.10.13 New Issue		KJ/JLM		
	Est Rev B 06.02.13 ECN 773 dwg @ rev.D		EC		
	Est Rev:C 07-05-28 As per Rev F		JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC 	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-043 CHG003	
2.0	D3391023 	Mid Tube Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) pick: Qty Part Number Description Batch 	
1	D3391-023 Mid Tube Assembly		
3.0	D3391025 	Aft Tube Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) pick: Qty Part Number Description Batch 	
1	D3391-025 Aft Tube Assembly		
4.0	D35641 	WEARSHOE	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Thursday, 11/15/2007 9:30:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 34838A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D35643 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1334052

FL

6.0 D35645 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1334806

FL

7.0 D35661 GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: 1334353

FL

8.0 D35665 GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1334354

FL

9.0 AN3C4A BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

Batch: m106093

FL

10.0 AN3C6A BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Batch: m105057

FL

11.0 AN3C7A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch: m105906

FL 07/11/16

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 34838A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 AN960C10L washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

washer

Batch: m106242

FL

13.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/023/025 with LPS-3 as per Dwg D3391

A/R LPS-3 m/05005

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment, using 7/16" "T" Pins.

A/R Sikaflex-241/291 m/05585

Expiry date: 08-07

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon m/04251

A/R Sikaflex-241/291 m/05585

Expiry date: 08-07

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

FL 07/11/16

①

14.0 QC5 INSPECT WORK TO CURRENT STEP



07.11.16

Comment: INSPECT WORK TO CURRENT STEP

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

*PP
341838*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/11/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 34838A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

11/15/17

Job Completion



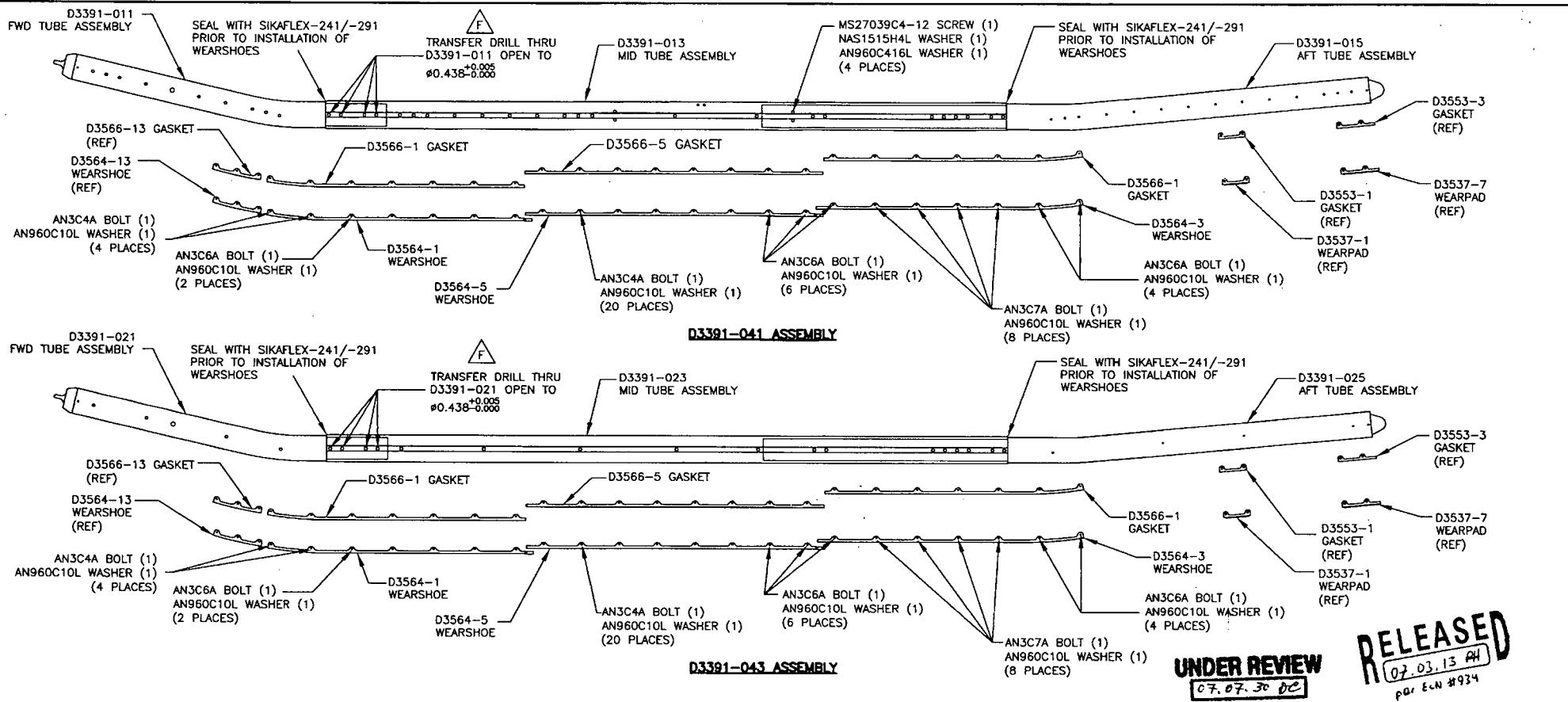
11/15/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
07.03.13 PH
PAR E-N #934

UNDER REVIEW
07.07.30 DC
CHANGING INSERTS

D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
.041	.043	D3391-041	FLOAT SKIDTUBE ASSEMBLY
X	X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	1	D3391-011	FWD TUBE ASSEMBLY
1	1	D3391-013	MID TUBE ASSEMBLY
1	1	D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-017	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
2	8	AN960C10L	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

GENERAL NOTES

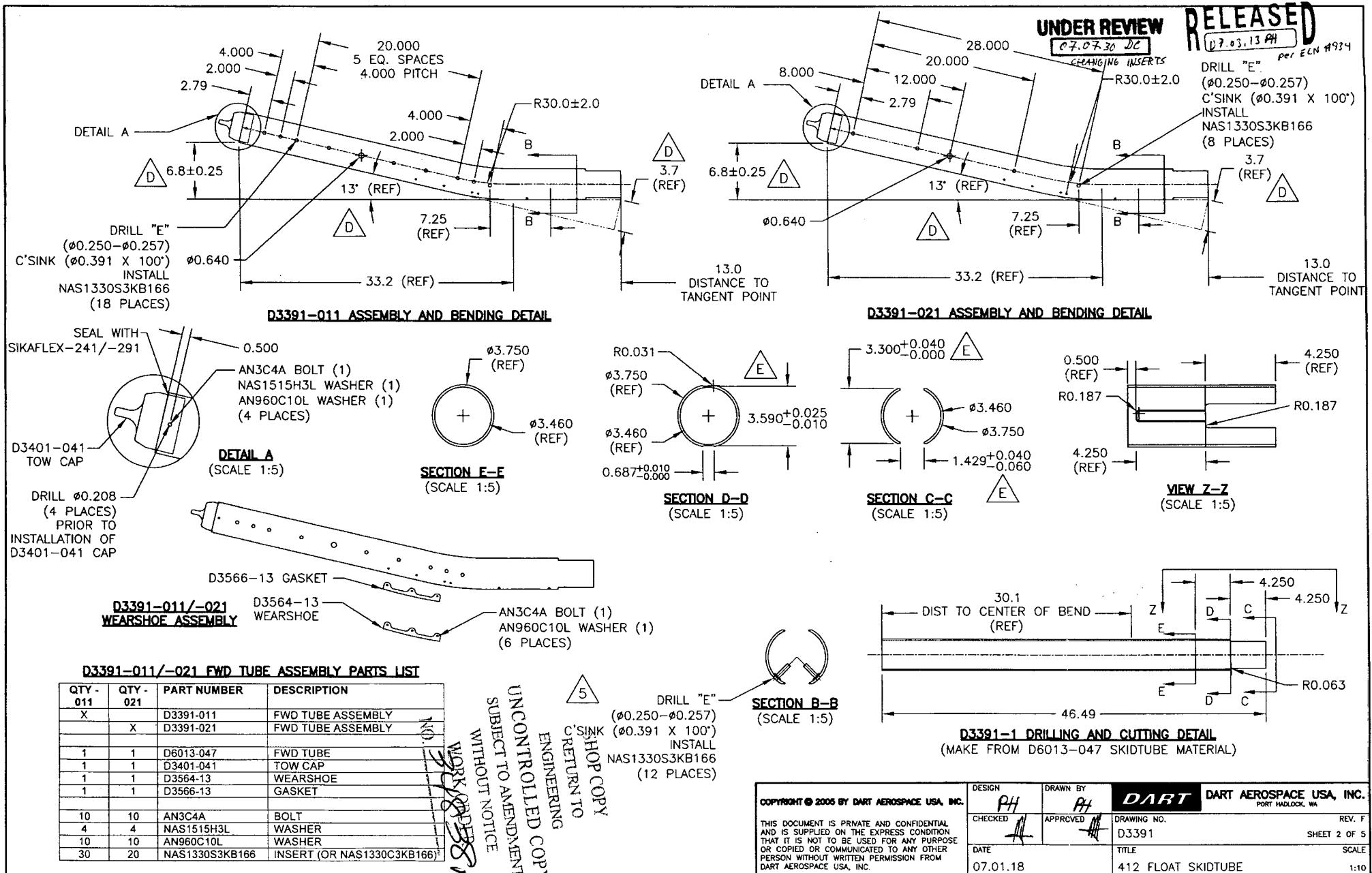
- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DTB217 TO LOCATE AND DRILL 'E' SIZE HOLES ($\varnothing0.250\text{--}\varnothing0.257$)
FOR WEARSHOE INSERTS. C'SINK $\varnothing0.391\text{--}\varnothing0.425 \times 100$ " AS APPLICABLE AND
INSTALL INSERTS EXCEPT WHERE INDICATED.

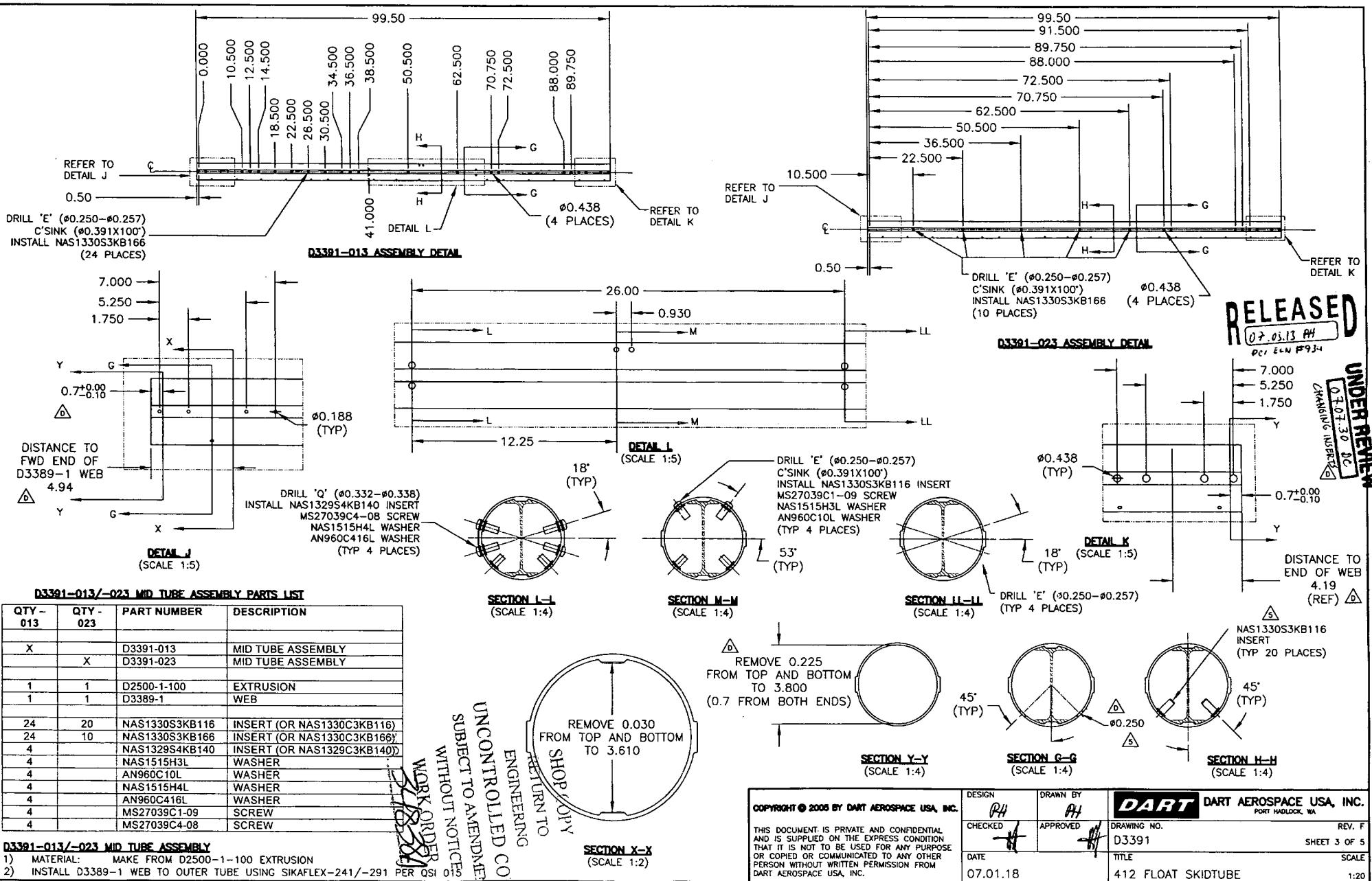
NO. 13-1838A
WORK ORDER
ENGINEERING
CONTROLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
RETURN TO
SHOP COPY
DRAFTING
NO. 13-1838A

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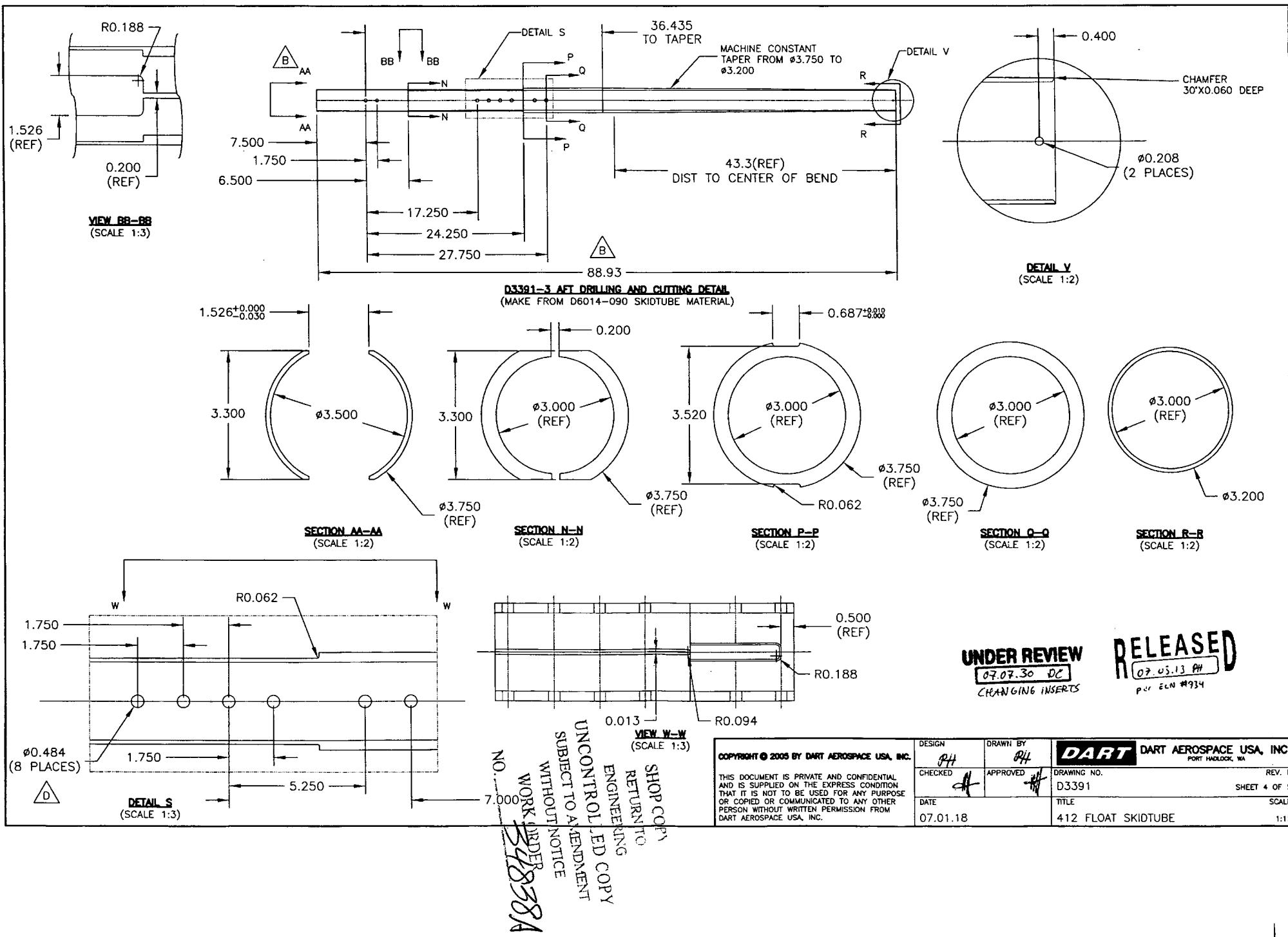
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DART AEROSPACE USA, INC.

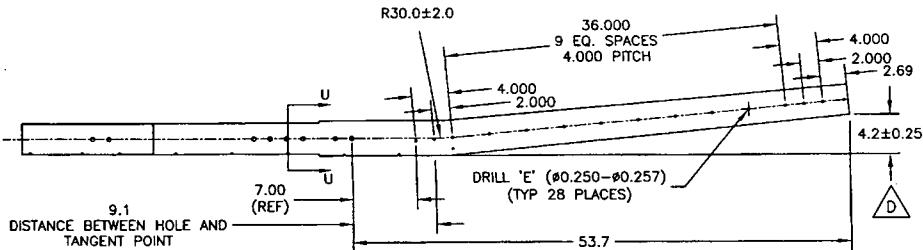
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
07.01.18	PH	REMOVED SS WEARSHOE, GASKET	REMOVE FWD SADDLE HOLE -011/-021
06.04.25		CHANGE TOLERANCE, EASE MANUFACTURE	
06.01.23		UPDATE TOLERANCE, CHANGE HOLE SIZE	
05.09.27		LENGTHEN AFT EXTENSION	
05.06.10		DRAWING UPDATES	
05.02.07		NEW ISSUE	
07.01.18	PH	DART AEROSPACE USA, INC.	PORT HADLOCK, WA
		DRAWING NO.	REV. F
		D3391	SHEET 1 OF 5
		TITLE	SCALE
		412 FLOAT SKIDTUBE	NTS



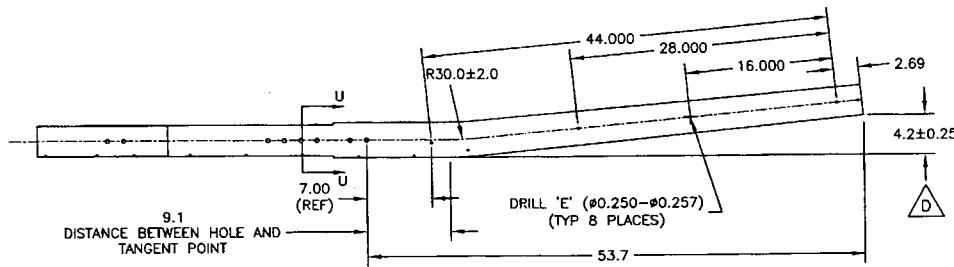


UNCONTROLLED SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER OS

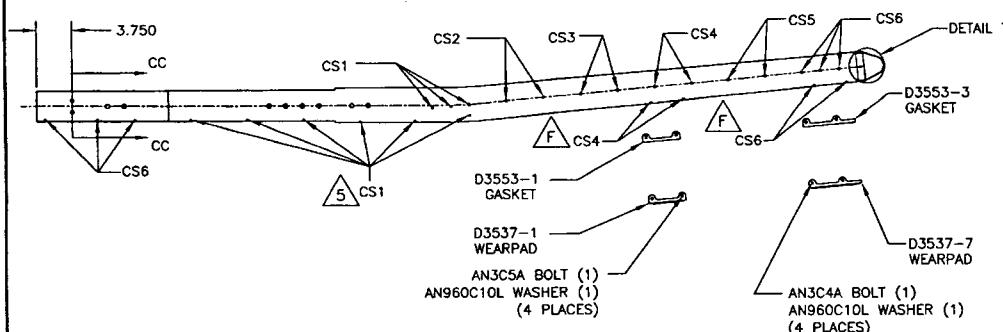




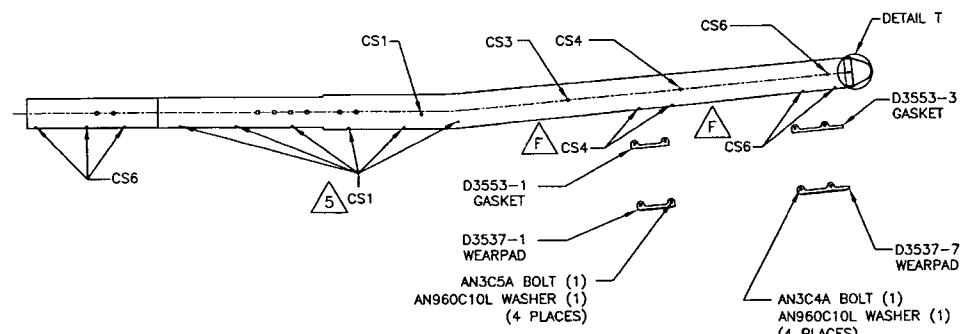
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



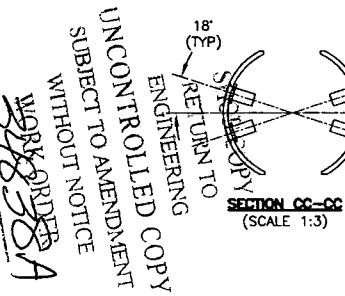
D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)



D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
X	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER



C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

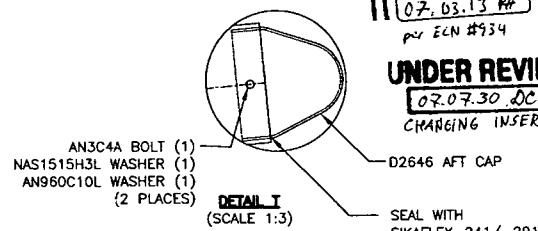
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DESIGN	DRAWN BY	DART	DART AEROSPACE USA, INC. PORT HADLOCK, WA
PH	PH		
checked	approved		
		DRAWING NO.	REV. F
		D3391	SHEET 5 OF 5
DATE	TITLE	SCALE	
07.01.18	412 FLOAT SKIDTUBE	1:12	

RELEASED
07.03.13 PH
PV ECN #934

UNDER REVIEW
07.07.30 DC
CHANGING INSERTS



07.07.30 DC

CHANGING INSERTS